

Work Order ID 58271

May 3, 2010 9:52:35 AM



Page 1

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Item Name: Side Door Assembly RH

Stop



Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

RV

Date: *10-5-03*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2991

D

IIN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-589-042

CHG005

8/10/06 lu

HJ for BG 10/06/11

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

IT 10-06-10

Ph >

W/O: 58271		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/06/08	# 111	Perm. change Tr. in D2991-2 as required to fit mock up 350 helicopter	AT	10-06-08			S 10/06/08
10/06/08	# 112	QC to inspect fit on 350 helicopter	AT	10-06-10			S 10/06/08

Part No: D350-589-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O: 58271		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-06-10	113	permanent change re-prime inside + pre-paint outside as per QSR 005 to cover of any marks from trimming primer B# 114013 paint B# 114772	BT	10-06-09	1		8
	114	QC 14	MA	10-06-10	1		10/06/10
			AA	10.06.10			

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Page 2

Item ID: D350-589-042

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Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly RH

Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

2T 10-06-10 Pto →

Pto →

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S. Woloski



160

0.00



Pick Kit





Packaging

Memo

0.00

Packaging

10-6-10 SP

W/O: 58271		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10.06.08	140	DRILL AFT LATCH 2.5" FROM BOTTOM INSTEAD OF 3.5"	RT	10-06-10	1	 10.06.08 DSI 042	 100610	
10-06-10	140	upon installation of 02586 Door latch, it was found that there wasn't enough clearance for the head of the screw MS27039-1-15 to allow the latch to close properly + allow sufficient thread showing on nut side of screw. Door latch was originally machined properly + within tolerance as per B57917. Remove just enough material to allow proper function	RT	10-06-10	1	 DSI 042	 10-06-10	

Part No: D350-589-042 PAR #: _____ Fault Category: Small Exp NCR: Yes No DQA: _____ Date: 10-06-16
 Resolution: rework Disposition: rework QA: N/C Closed: _____ Date: 10/06/16

NCR: 58271		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-06-09	161	gel cant on top left corner of door cracked. Noticed during trimming of door Note: Minor rework. R.C. Unknown - handling.	DSI 042	sand down area to cloth. make sure no damage to door itself. Fill area w/ polyester filler + repaint as per QSI 005	RT 10-06-09	6 10/06/10	DSI 042	10/06/10

NOTE: Date & initial all entries

Work Order ID 58271

May 3, 2010 9:52:35 AM



Page 3

Item ID: D350-589-042

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Setup Start



Revision ID:

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Item Name: Side Door Assembly RH

Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

8/10/06/14

Memo

0.00

40

180



Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-589-042

Location: 2112
PPP rev: 2

0.00

0.00

10-6-14 J

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/15 J
mf
10-6-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May 3, 2010 9:52:39 AM

Page 1

Work Order ID: 58271

Parent Item: D350-589-042

Parent Item Name: Side Door Assembly RH

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
verified : DD IPP rev:D 10.04.29 revise bom

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2991-2 Manufactured No



Side Door

110 Each

1.0000

1

~~35~~ 358273



25 10-06-08

Location

Loc Qty

Loc Code

CA

1

56810

1

Each

15.0000

1

D3894-1



Doubler

Manufactured No

~~110~~
160



10-6-10 J

Location

Loc Qty

Loc Code

ST095

15

~~46896~~

15

Each

17.0000

1

D3895-1



Doubler

Manufactured No

~~110~~
160



10-6-10 J

Location

Loc Qty

Loc Code

ST095

17

45585

1

46897

3

53964

13

NAS1149D0363J



Washer

Purchased No

110

Each

1,214.000

3



10-06-10

Location

Loc Qty

Loc Code

ST298

1214

113288

2

114292

1212

23

W/O:		WORK ORDER CHANGES					
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May 3, 2010 9:52:40 AM

Page 2

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Parent Item: D350-589-042

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 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD IPP rev:D 10.04.29 revise bom

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D2621 Manufactured No 110 Each 109.0000 3



Latch Plate, 350 Spacepod



RT 10-06-10

Location Loc Qty Loc Code

ST021 109
 46842 40
 56526 69

X3

D2586 Manufactured No 110 Each 65.0000 3



Door Latch



RT 10-06-10

Location Loc Qty Loc Code

ST204 65
 55314 65

MS27039-1-15 Purchased No 110 Each 98.0000 3



Screw



RT 10-06-10

Location Loc Qty Loc Code

ST292 98
 112794 3
 114056 95

X3

D2464-1700 Manufactured No 110 Each 0.0000 1



Neoprene Seal



RT 10-06-10

May 3, 2010 9:52:40 AM

Shop Packet Print

Page 2

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 verified: DD IPP rev:D 10.04.29 revise bom

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

D3085-041 Manufactured No 110 Each 8.0000 1
 prop ass'y

Location	Loc Qty	Loc Code
ST271	8	
47687	4	
57545	4	

D2585 Manufactured No 110 Each 87.0000 3
 Mounting Channel

Location	Loc Qty	Loc Code
ST018	49	
55313	49	
ST019	38	
56524	38	

MS21042L3 Purchased No 110 Each 1,770.000 6
 Nut

Location	Loc Qty	Loc Code
ST300	1770	
113537	20	
113644	750	
114523	1000	

MS20470AD4-5 Purchased No 160 Each 217.0000 6
 Rivet, Universal Head

Location	Loc Qty	Loc Code
ST319	217	
111916	217	

May 3, 2010 9:52:40 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 58271

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 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD IPP rev:D 10.04.29 revise bom

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

AN3-4A



Bolt

Purchased No 160 Each 1,448.000 6



10-6-10sf

Location	Loc Qty	Loc Code
ST350	1448	
104214	287	
104291	300	
104322	200	
104374	200	
104625	300	
104817	161	

D2237



Striker Plate

Manufactured No 160 Each 75.0000 3



10-6-10sf

Location	Loc Qty	Loc Code
ST009	40	
57255	40	
ST010	35	
55312	35	

D2589



Keys, Key Chain, 350 Hinge

Manufactured No 160 Each 265.0000 1



10-6-10sf

Location	Loc Qty	Loc Code
ST019	265	
58194	265	

3

May 3, 2010 9:52:40 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May 3, 2010 9:52:40 AM

Page 5

Work Order ID: 58271



Parent Item: D350-589-042



Parent Item Name: Side Door Assembly RH

Start Date: 03/05/2010

Required Date: 13/05/2010

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC
 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC
 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC
 verified : DD IPP rev:D 10.04.29 revise bom

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

160

Each

1,770.000

6



Nut



10-6-16 sf

Location

Loc Qty

Loc Code

ST300

1770

113537

20

113644

750

114523

1000

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

D2991-1/-2/-3 SIDE DOOR

NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58274
PS10-5-03

RELEASED
2009-10-30

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2991	REV. D SHEET 1 OF 5
TITLE SIDE DOOR	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

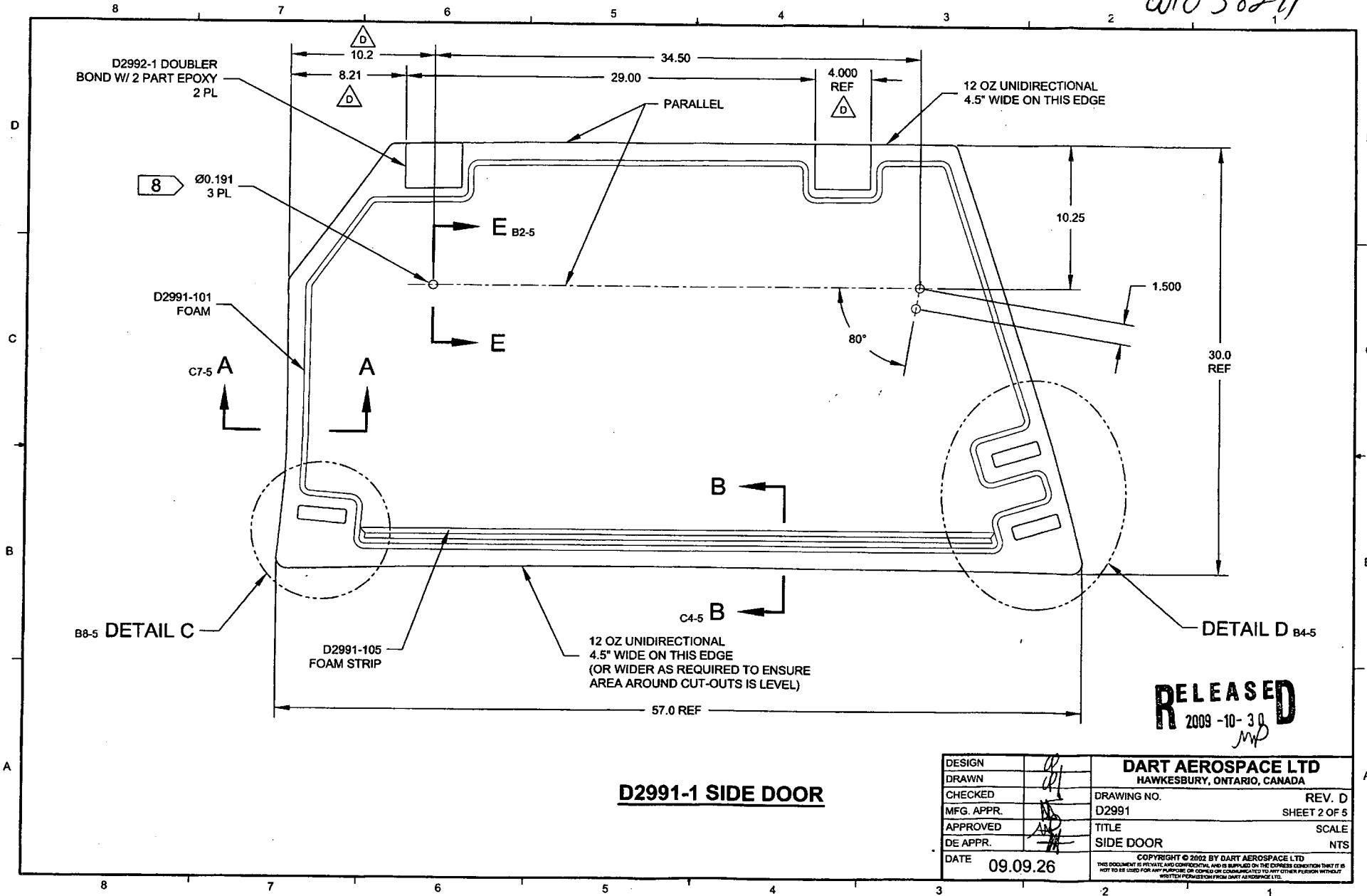
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/0 58271



D2991-1 SIDE DOOR

RELEASED
2009-10-30
MP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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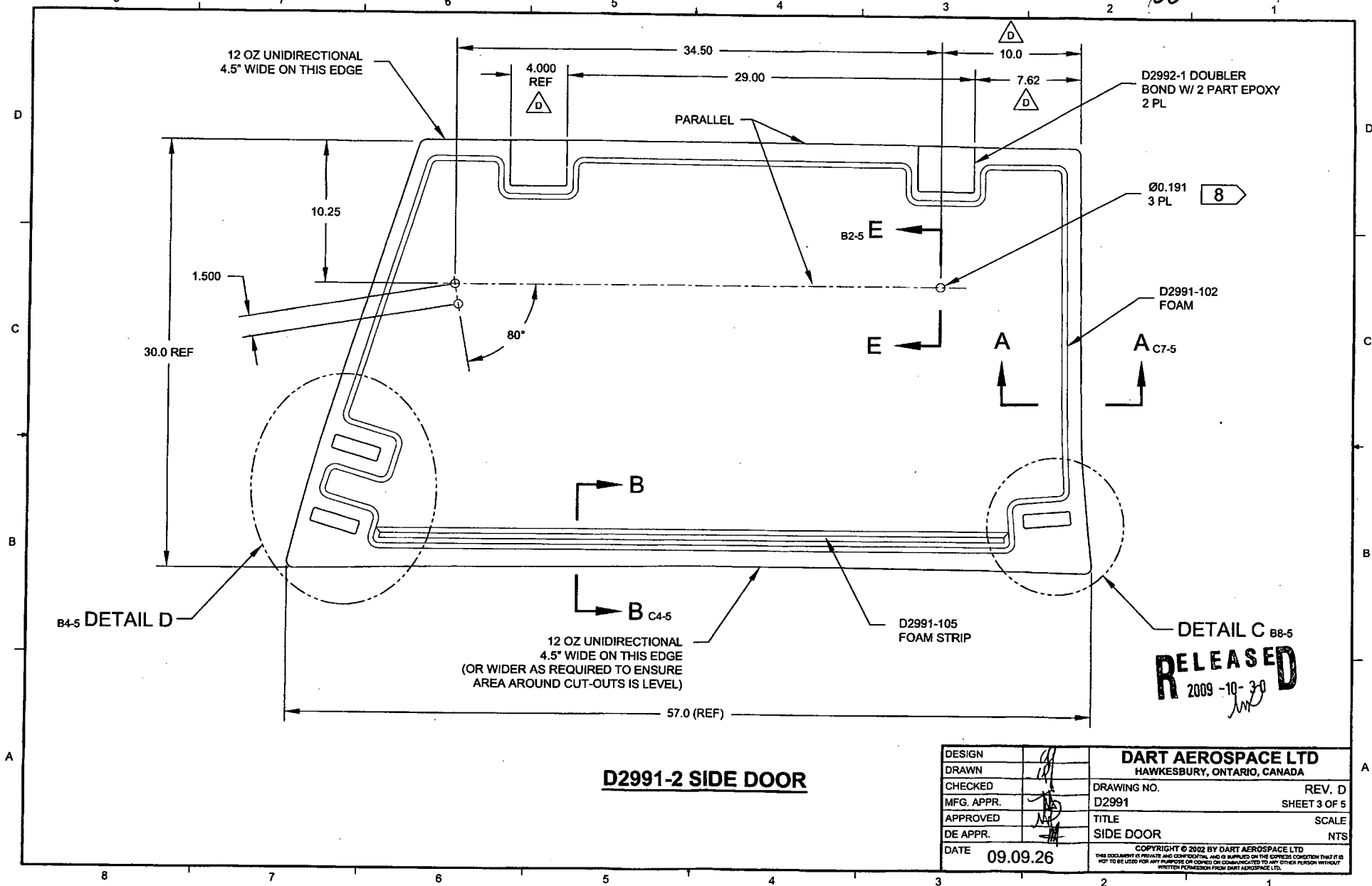
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W1058271



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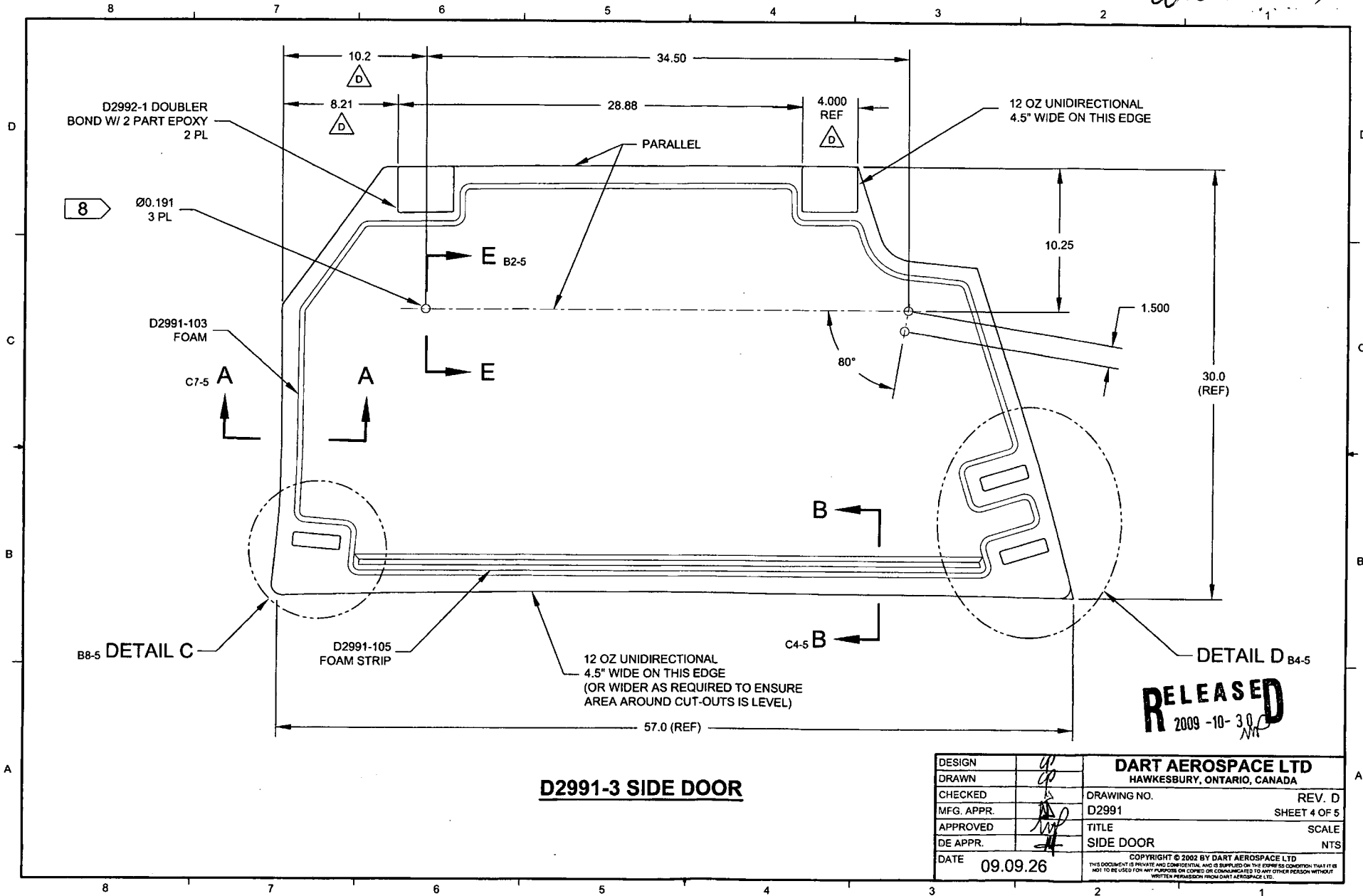
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W1058271



RELEASED
2009-10-30

DESIGN	UP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	WJ	D2991	SHEET 4 OF 5
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	SIDE DOOR	NTS
DATE	09.09.26	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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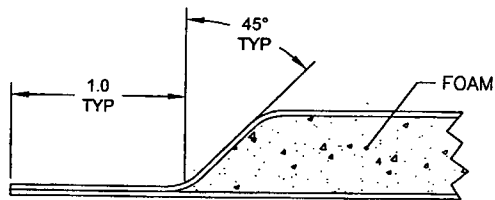
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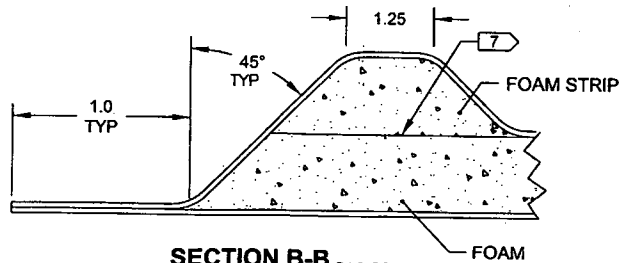
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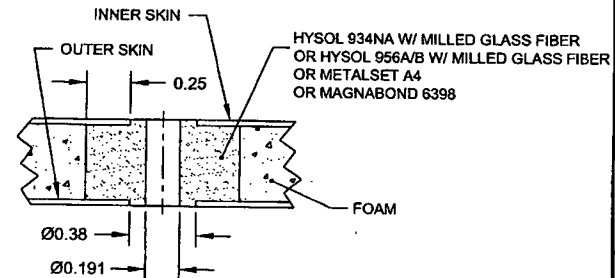
W/O 58271



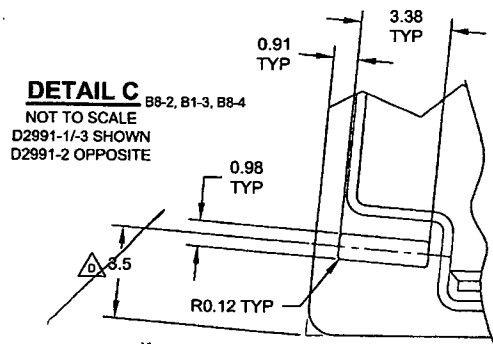
SECTION A-A C7-2, C2-3, C7-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



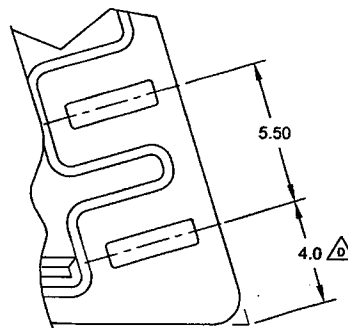
SECTION B-B B4-2, B5-3, B4-4
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E D6-2, D3-3, C6-4
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE



DETAIL C B8-2, B1-3, B8-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D B1-2, B8-3, B1-4
NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE

RELEASED
2009-10-30

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2991	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NTS
DATE	09.09.26	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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2.5"
P10.06.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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Revision: 1

52-00-00

Page 17 (18 blank) of 18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER
REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for the relocation of the door switch when the D35X-589-041/-042/-043 Side Door Assemblies are installed per D350-589 Rev. E and earlier and to clarify that the OEM center latch is not required with the D35X-589-041/-042/-043 kits.

The DSI 9446-011 Switch Relocation Kit may be installed by relocating the door switch using the following procedure:

- 1) Remove the existing door switch (p/n 2-5445), switch support (p/n 350A67-6323-32) and spring (p/n 350A67-6323-31) from the forward lower edge of the cargo compartment.
- 2) Position the D3894-1 switch plate near the bottom of the flange adjacent to the cargo compartment floor so that the switch will contact the door directly. See Figure 1.
- 3) Locate and drill 2x Ø0.129 (#30 drill) holes from D3894-1 switch plate to the cargo compartment flange. Deburr holes and attach D3894-1 switch plate to the flange of the cargo compartment using 2x MS20470AD4 rivets.
- 4) Position the door switch in the hole provided in the D3894-1 switch plate.
- 5) Reconnect wiring to switch (if removed) and verify that switch operates correctly. It may be necessary to hand-form/trim the D3894-1 switch plate slightly to ensure that the switch contacts the door properly.

If the cargo compartment has a second switch installed in the center latch, it is not necessary to relocate this switch. The wiring should be removed and stowed so that this switch no longer turns on the cockpit indication.

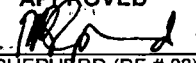
There is no weight and balance change for the installation of the DSI 9446-011 switch relocation kit.






The D3894-1 switch plate will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9446-011	Switch Relocation Kit
1	D3894-1	Switch Plate

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 09.02.03
CERT. NO. SH92-41
ISSUE NO. 7

A	NEW ISSUE	09.02.03
REV.	DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9446 SHEET 1 OF 2
APPROVED		TITLE SCALE
DE APPR.		SWITCH RELOCATION NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E AND EARLIER
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1 AND EARLIER

REF. TCCA STC: SH92-41
REF. FAA STC: SH1012NE
REF. AUSTRIAN STC: ACG.21NE2.093

The purpose of this DSI is to provide instruction for recessing the forward upper latch of the D35X-589-041/-042/-043 Side Door Assemblies for compatability with OEM sliding doors. Without this modification the OEM sliding door may contact the upper latch as the door is opened.

The DSI 9447-011 Latch Adjustment Kit may be installed as follows:

- 1) Remove sliding door guide (p/n 350A21-1375-21/-20) and shim (p/n 350A21-1376-20) from existing door and relocate to D35X-589-041/-042/-043 door assembly. See Figure 2 for drilling and repair details. Install using existing hardware.
- 2) Mark around the edge of the upper forward D2586 door latch on the outer door surface.
- 3) Remove the upper forward D2586 door latch and trim the hole to the line marked in the previous step. D2586 door latch should now be able to pass through the hole.
- 4) Position the D3895-1 doubler on the inside of the door with the cutout centered over the newly enlarged hole.
- 5) Transfer drill 16x $\phi 0.129$ (#30 drill) from the doubler to the D35X-589-041/-042/-043 side door. Countersink the 16 holes $\phi 0.179 \times 100^\circ$ from the outside of the door. Deburr holes and attach D3895-1 doubler to the D35X-589-041/-042/-043 door with qty. (16) MS20426AD4 rivets. See Figure 1.
- 6) Re-install the D2586 door latch per D350-589 and/or ICA-D350-589.
- 7) Verify that the door closes and latches correctly. Adjust latches per ICA-D350-589.
- 8) Apply blade tape (Ref. 3M p/n 8560-2) to the D35X-589-041/-042/-043 side door to prevent contact wear from the OEM sliding door.

There is no weight and balance change for the installation of the DSI 9447-011 latch adjustment kit.

The D3895-1 doubler will be included with D35X-589-041/-042/-043 kits at CHG 3 and subsequent.

PARTS LIST

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9447-011	Latch Adjustment Kit
1	D3895-1	Doubler

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.02.04
CERT. NO.: SH92-41
ISSUE NO.: 7

A	NEW ISSUE	BY	09.02.04
REV.	DESCRIPTION	DATE	
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9447	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LATCH ADJUSTMENT	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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